: FITTING

: D32571

: N/A

D3257 REV A1

: 16/04/2008

Qty:

Date: Upr." Monday, 07/04/2008 11:47:11 AM

Julie Lecocq

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer : CU-DAR001 Dart Helicopters Services

Job Number

38429

Estimate Number

: 11160

P.O. Number

: 07/04/2008

This Issue

: NC

First Issue : 11

38192 **Previous Run**

Written By

Prsht Rev.

Checked & Approved By Comment

: Est:

S.O. No.

: MACHINED PARTS

Type

A 04.04.14

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

AISI 303 Bar .5 x .5

M303B0500X0500 1.0

Comment: Qty.:

0.1147 f(s)/Unit

Total: 1.3759 f(s)

AISI 303 Bar .5 x .5 Material: AISI 303 SS Bar (M303B0.500x0.500) Identify for D3257-1

Batch: 108 553

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank: 0.500" x 0.500" x 1.180" long Bar

B. A

H.A

Each

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA420 and Dwg D3257

Deburr

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



5.0

QC8

Comment: SECOND CHECK



Date:

Monday, 07/04/2008 11:47:11 AM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Part Number: D32571

Job Number: 38429

Seq. #:

Job Number:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:_

QC21

Comment: FINAL IN

FINAL INSPECTION/W/O RELEASE

7.0

Job Completion



TION/W/O RELEASE

U St. 07.18

DART AEROSPACE LTD	Work Order:	38429
Description: Fitting	Part Number:	D3257-1
Inspection Dwg: D3257 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing	Tolorono	Actual Accept			Method of		
Dimension	Tolerance	Dimension	sion Accept	Reject	Inspection	Comments	
0.125	+/-0.010	0.126	/			- t	
0.135	+0.010/-0.007	0.129		·			
1.080	+/-0.010	1.080	1	, .			
0.330	+/-0.010	0.330	/				
0.385	+/-0.010	0.385	1			11	
Ø0.191	+0.005/-0.000	Ø0.193	√	3			
R0.193	+/-0.010	R 0. 193	✓				
0.887	+/-0.010	0.885	/			14-34	
0.385	+/-0.010	386		è			
0.192	+/-0.005	0.194	~				
Ø0.230 x 100°	+/-0.010	0.230 X 108					
0.135	+0.010/-0.007	-128	/				
v.						. ^	
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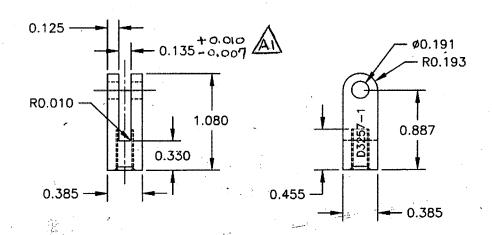
_		•			
Measured by:	101.07-17	Audited by:	SP,	Prototype Approval:	N/A
Date:		Date:	08/07/17	Date:	N/A

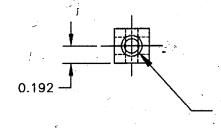
Rev	Date	Change	Revised by	Approved_
Α	04.12.10	New Issue	KJ/JLM , ,	1
В	05.06.20	0.455 dimension removed	KJ/JLM of	\(\(\sqrt{1} \)





	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
ı	CHECK	(ED#	APPROVED	DRAWING NO.	REV. A	
	1.5	#	1 -11	D3257	SHEET 1 OF 1	
	DATE		<u> </u>	TITLE	SCALE	
	04.01.27			FITTING		
0.17	Α	lı	04.01.27	NEW ISSUE		
-	A۱	4	04.12.14	ADD TOLERANCE		





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WORK ORDER

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE INCHES
- ENGRAVE DART P/N AS SHOWN

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